

EUROPEAN PATENT OFFICE

Patent Abstracts of Japan

PUBLICATION NUMBER : 04138238
 PUBLICATION DATE : 12-05-92

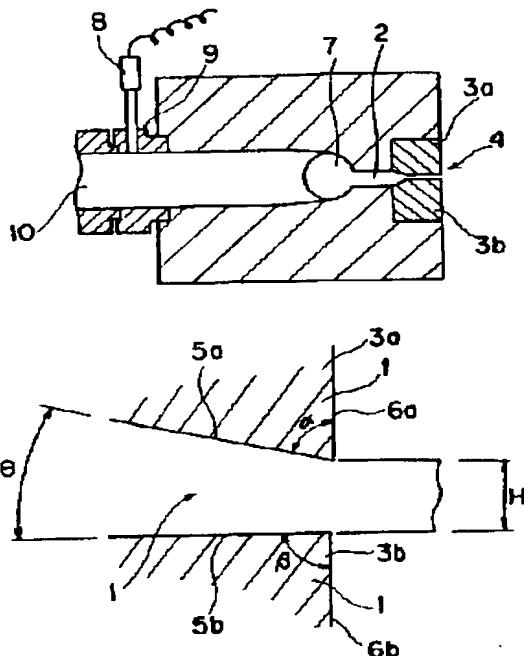
APPLICATION DATE : 29-09-90
 APPLICATION NUMBER : 02261452

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INT.CL. : B29C 47/14 B29C 47/92 // B29C 59/00
 B29L 7:00

TITLE : MANUFACTURE OF EMBOSSED
 THERMOPLASTIC RESIN SHEET



ABSTRACT : PURPOSE: To apply required embossing simply by varying a lip by forming respective land faces formed on the inner faces of a couple of lips flat to the ends of lips and forming a space between respective land faces smaller successively toward the ends of lips.

CONSTITUTION: Respective land faces 5a and 5b formed on the inner faces of a couple of lips 3a and 3b are formed flat to the ends of lips, and a space between respective land faces 5a and 5b is formed smaller successively toward the ends of lips. Further, thermoplastic resin is extruded under the condition that the ratio V/H of extruding speed V to a slit space H formed between a couple of said lips 3a and 3b at the ends of lips 3a and 3b makes a value larger than the ratio V/H (critical value) in the minimum vale of surface roughness of a sheet when the surface roughness is reduced and then increased following the increase of the ratio V/H.

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